

Work Order ID 85254

85254

Page 1

June-05-12 9:12:13 AM

Item ID: D3264-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 05/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/05 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3264	Rev A								

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 5.700" LONG

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOILIO FA447

FOILIO REV: B

DWG REV: A

DEBURR AS PER DWG

PD

12/06/08

8

0

FK 12/06/10

PTO

NCR: ~~Yes~~ / No

WORK ORDER NON-CONFORMANCE / UPDATE

DOA: Jul Date: 12/06/16QA Closed: Jul Date: 12/6/18

Work Order: <u>85254</u> Part No. <u>3264-1</u> NCR No. <u>12-1503</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Crosstube <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input checked="" type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td style="border: none;"></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> <td style="border: none;"></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>																								
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input checked="" type="checkbox"/> Material <input type="checkbox"/> Offset/Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unauthorized <input type="checkbox"/>	<u>12/06/16</u>	<u>110</u>	<u>1</u>	<u>Tightened the vice to much therefor the weld is out of tolerance.</u>	<u>S</u> <u>12/04/17</u> <u>12/06/11</u>	<u>Scrap Desty + Repair</u> <u>R 121380</u>	<u>F.K</u> <u>12/06/10</u>	<u>ET</u> <u>12-06-11</u>	<u>S</u> <u>12/06/11</u>																		
FAULT CATEGORY																											
Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many			General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing			<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material <input checked="" type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other <u>Not enough info.</u> <u>on Folio</u>																		

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00				8	8		
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				8			
Hand Finishing									

OK 12-06-11 (X8)

8 NG 12-6-11

Work Order ID 85254

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Stop

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Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 8.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

Powder Coating

0.00

Start Time: 3:50
Temp: 320°F
Finish Time: 4:20

8X

MT
12/06/11

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

Quality Control

0.00

8x 6 9u 12/06/13

170

Identify as per dwg & Stock Location: 5198A

0.00

170

Packaging

Memo

Packaging

0.00

8

5.5 12/06/12

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

D12-06-12

Picklist Print

June-05-12 9:12:16 AM

Page 1

Work Order ID: 85254

85254

Parent Item: D3264-1

D3264-1

Parent Item Name: Bracket

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	12.7417		4			

M6061T6B1 250X04 500

6061-T6 Bar 1.25 X 4.50

**

PO

12/06/09

Location

Loc Qty

Loc Code

MAT004

12.7417

112628

0.7417

121380

12

4.5

DART AEROSPACE LTD		Work Order:	<i>25254</i>
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST





☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	.687	✓		FK-04	Vern.
0.063	+/-0.010	.068	✓		"	"
0.125	+/-0.010	.132	✓		"	"
0.875	+0.010/-0.020	.874	✓		"	"
0.062	+/-0.010	.064	✓		"	"
R0.03	+/-0.030	.03	✓		rad gauge	
R0.13	+/-0.030	.13	✓		" "	
1.00	+/-0.030	1.00	✓		FK-04	Vern.
0.125	+/-0.010	.125	✓		"	"
0.600	+/-0.010	.601	✓		"	"
4.000	+/-0.005	4.000	✓		"	"
0.750	+/-0.010	.750	✓		"	"
Ø0.194	+0.005/-0.000	.195	✓		"	"
5.50	+/-0.030	5.500	✓		"	"
0.125	+/-0.010	.127	✓		"	"
0.063	+/-0.010	.063	✓		"	"
R0.25	+/-0.030	.25	✓		rad gauge	
4.27	+/-0.030	4.27	✓		FK-04	Vern.
R0.30	+/-0.030	.30	✓		rad gauge	

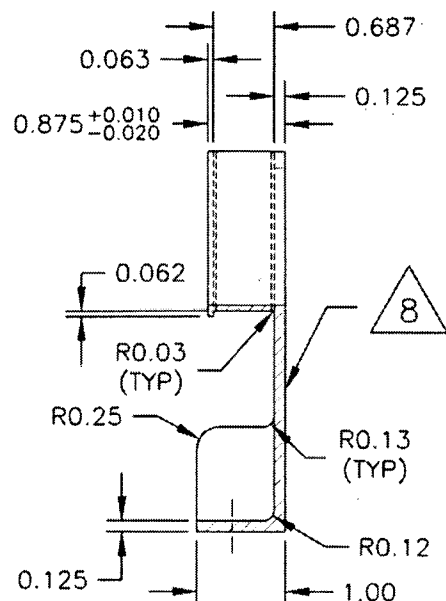
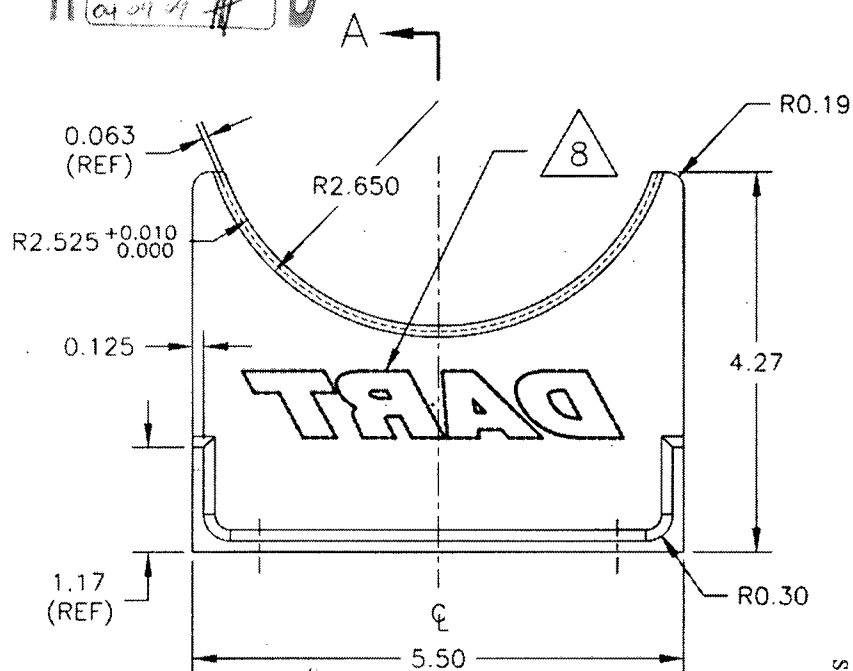
Measured by: <i>FK</i>	Audited by: <i>AM/ET</i>	Prototype Approval:	N/A
Date: <i>12/06/10</i>	Date: <i>12-06-11</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	<i>JA</i>

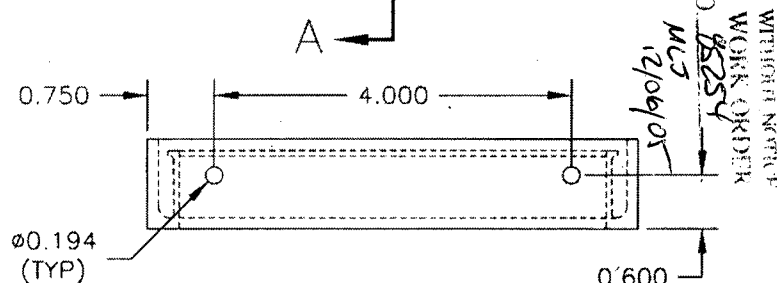


DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. REV. A D3264 SHEET 1 OF 1	
DATE 04.04.20		TITLE BRACKET		SCALE 1:2	
A	04.04.20		NEW ISSUE		

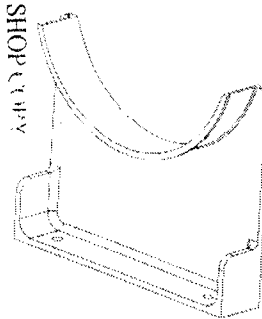
RELEASED
01 09 09



SECTION A-A



SHOP COPY
RETURN TO
ENGINEER, c/o
UNCONTROLLED
SUBJECT TO AMENDMENT



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH
(MIN) TOOL RADIUS OF 0.25

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